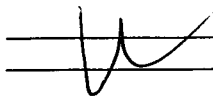
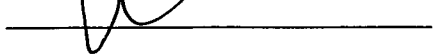


Date: Thursday, 09/11/2006 10:19:36 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D412-664-203
Job Number : 29386	
Estimate Number : 10804	
P.O. Number :	Part Number : D412664203A
This Issue : 09/11/2006 S.O. No. :	Drawing Number : NCR 095
Prsht Rev. : NC	Project Number :
First Issue : / / Type : R&D GENERAL	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 16/11/2006 Qty: 2 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
OPEN RTN FROM BHT
RTN # 198992 (REF: NCR 095)
RECORD B/N'S
B 27387
B 27386

RTN from BHT

*SEE R532
was return and shipped back to customer.*

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
REMOVE SUPPORT D2896-1
FROM CROSSTUBES AND LABEL SUPPORT
WITH B/N OF CROSSTUBE IT CAME OFF OF

AT 06-11-09

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
REMOVE CENTRE ABRASION STRIP
AND CLEAN OFF ALL ADHESIVE RESIDUE

AT 06-11-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 09/11/2006 10:19:36 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-664-203

Job Number: 29386

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Doc-11-14 (2)

5.0	SPRAY PAINTING	SPRAY PAINTING
-----	----------------	----------------



Comment: SPRAY PAINTING
RE-PAINT SECTION OF CROSSTUBE
BETWEEN THE TWO CHAFING SHIELDS
AS PER QSI 005

Job 11-14

(2)

6.0	QC14	Inspect Spray Paint
-----	------	---------------------



Comment: Inspect Spray Paint

Job 11-15

7.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
INSTALL SUPPORT D2896-1 ENSURING
B/N MATCHES CROSSTUBE AS PER
DSI 9357

8.0	MS2192030	clamp(per MIL-DTL-8783C)
-----	-----------	--------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
clamp(per MIL-DTL-8783C)

M101568 NP6-11-15 #2

9.0	D2182B	Neoprene Cushion-.750 bl
-----	--------	--------------------------



Comment: Qty.: 0.8750 f(s)/Unit Total : 1.7500 f(s)
Neoprene Cushion-.750 bl

B28042 NP6-11-15

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Job 11-15 (2)

11.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Job 11-15 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 09/11/2006 10:19:36 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-664-203

Job Number: 29386

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP

LB 06/11/15 (2)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

LB 06/11/15

Job Completion



U 06-11-15

DART			
TRANSPORT CANADA APPROVAL - 00569			
P/N	D412-664-203A	Q=16	CHG002
DESC	Crosstube Aft High	STC	SH01-9
LOT	B27386	STC	SR01298NY
MODEL	Bell 412	STC	
MADE IN CANADA			

TEL: 1-613-632-3336
FAX: 1-613-632-4443





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9357	REV. A SHEET 1 OF 2
DATE 06.10.25		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS
A	06.10.25	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-664 Rev. C AND
INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D212-664 Rev. 2
REF. CANADIAN STC: SH01-9
REF. FAA STC: SR01298NY

For D412-664-203 Aft Crosstubes at CHG 002 or later, the D2856-600-1087 Abrasion Strip has been removed, the center D2896-1 Support has been bonded onto the crosstubes using Magnobond 6398 and D2182B058 Rubber Cushions have been installed underneath the MS21920-30 Clamps. Amend Parts List of IIN-D212-664 Section 5 and ICA-D212-664 Section 32.8 as follows:

Remove:

Item	QTY -203	Part Number	Description
32	1	D2856-600-1087	ABRASION STRIP

Add:

Item	QTY -203	Part Number	Description
41	2	D2182B058	RUBBER CUSHION

To prevent the center support from shifting on D412-664-203 Crosstubes at CHG 001, the D2896-1 Support should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D212-664 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty(2) MS21920-30 Clamps from the crosstube that fasten the D2896-1 Supports to the crosstube.
- 3) Remove the D2856-600-1087 Abrasion Strip from the crosstube per section 32.5 of ICA-D212-664.
- 4) Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection.
- 5) Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2896-1 Support and re-install the Support on the crosstube as shown in Figure 1. Use rocker beam assembly to properly align the D2896-1 Support. Ensure the Rocker Beam Assembly can move freely without any friction with other parts. Install a D2182B058 Rubber Cushion on each MS21920-30 Clamp. Position and secure the D2896-1 Support on the crosstube using MS21920-30 Clamps. Torque clamps 80-100 in-lb. Let the D412-664-203 Crosstube Assembly cure before re-installing the crosstube or the aircraft.
- 6) Re-install the D412-664-203 crosstube per section 32.2.5 through 32.2.9 of ICA-D212-664.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.10.25
CERT. NO.: SH01-9
ISSUE: 3

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Date: Thursday, 11/9/2006 4:37:06 PM
 User: Kim Johnston

Process Sheet

45

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D412-664-203
Job Number : 29386	
Estimate Number : 10804	
P.O. Number :	Part Number : D412664203
This Issue : 11/9/2006 S.O. No. :	Drawing Number : NCR 095
Prsht Rev. : NC	Project Number :
First Issue : 11/9/2006 Type : R&D GENERAL	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 11/16/2006 Qty: 2 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

PAPERWORK & LABELS READ.

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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06.11.10

Comment: PACKAGING RESOURCE #1
 OPEN RTN FROM BHT
 RTN # 198992 (REF: NCR 095)
 RECORD B/N'S
 B _____
 B _____

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
 REMOVE SUPPORT D2896-1
 FROM CROSSTUBES AND LABEL SUPPORT
 WITH B/N OF CROSSTUBE IT CAME OFF OF

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
 REMOVE CENTRE ABRASION STRIP
 AND CLEAN OFF ALL ADHESIVE RESIDUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Part Tracking by Batch # From : 29386 To : 29386

<u>Item</u>	<u>Order</u>	<u>Shipped</u>	<u>Batch</u>	<u>Qty</u>	<u>Price</u>	<u>Cust PO</u>	<u>Ship To</u>	<u>Ship To Name</u>	<u>City</u>	<u>State</u>	<u>Country</u>	<u>Contact</u>	<u>Phone</u>
D412-664-203A	OR000003095	02/26/07	29386	1	4,647.17 USD	8004358	ALOG01	Bell-Helicopter Textron/Air Logistics LLC	Mirabel	QC	Canada	Manon Oztas	4504373400
D412-664-203A	OR000002471	11/15/06	29386	2	0.00 USD	8003541	ALOG01	Bell-Helicopter Textron/Air Logistics LLC	Mirabel	QC	Canada	Manon Oztas	4504373400

2532

Part Tracking by Batch # From : 27387 To : 27387

<u>Item</u>	<u>Order</u>	<u>Shipped</u>	<u>Batch</u>	<u>Qty</u>	<u>Price</u>	<u>Cust PO</u>	<u>Ship To</u>	<u>Ship To Name</u>	<u>City</u>	<u>State</u>	<u>Country</u>	<u>Contact</u>	<u>Phone</u>
D412-664-203A	OR000001363	10/10/06	27387	1	4,706.00 USD	8002271	ALOG01	Bell-Helicopter Textron/Air Logistics LLC	Mirabel	QC	Canada	Manon Oztas	4504373400

2532